

Work Order ID 69397

Wednesday, June 15, 2011 7:39:55 AM



Page 1

Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011 Start Qty: 2.00

Required Date: 5/16/2011 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *W*

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

(I LED) Put Labels on shoes

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: *1109929*
COAT exposed HARDWARE WITH LPS PROCYON
A/R LPS PROCYON BATCH: *1114695*

EP 11/06/15 (2)

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Item ID: D412-630-034

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Setup Start

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Stop

Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control



8 w/06/15

2 RH

11/16/15 2

8 w/06/15

2 RH

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Item ID: D412-630-034

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D412-630-034 Location: _____ PPP Rev: <u>A</u>	0.00							
160 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

6/16/16 (2)

11/6/16

MF
11-06-16

Picklist Print

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Page 1

Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding




Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn1019, added D2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8  Nut		Purchased	No			110	Each	39.0000	2	4		5/11/06/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		39							
				111819		9							
				117771		30							
AN3C21A  BOLT		Purchased	No			110	Each	93.0000	2	4		5/11/06/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		93							
				109148		23							
				117366		20							
				117514		50							
AN44C7A  Eyebolt		Purchased	No			130	Each	73.0000	2	2		5/16/15 d(2)	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST362		73							
				109013		33							
				111308		40							

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C10A

Purchased

No

130

Each

81.0000



Bolt



1 2

Location

Loc Qty

Loc Code

ST356

81

111295

4

112243

47

114523

30

2

AN4C15A

Purchased

No

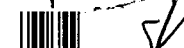
130

Each

125.0000



Bolt



2 4

Location

Loc Qty

Loc Code

ST358

125

115835

25

115936

2

117441

48

117795

50

4

AN4C6A

Purchased

No

130

Each

346.0000



Bolt



1 2

Location

Loc Qty

Loc Code

FG

4

103344

4

ST306

50

117313

50

ST356

292

116704

17

117619

150

117794

50

117872

75

2

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C15A
Bolt

Purchased No

130 Each

73.0000

2

4



5/16/15

Location

Loc Qty

Loc Code

ST339

73

111819

23

117764

25

117885

25

4

AN8C16
Bolt

Purchased No

110 Each

53.0000

2

4



5/11/06/15

Location

Loc Qty

Loc Code

ST345

53

106066

53

4

D2012-107
Clevis

Manufactured No

110 Each

25.0000

1

2



5/11/06/15

Location

Loc Qty

Loc Code

WA005

25

66811

25

2

D2803-042
Bracket Assembly

Manufactured No

110 Each

5.0000

1

2



5/11/06/15

Location

Loc Qty

Loc Code

ST149

5

64093

5

2

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2804-042



Bracket Assembly

Manufactured No

110

Each

3.0000

1

2



5/11/06/15

Location

Loc Qty

Loc Code

ST150

3

66643

3

Manufactured No

130

Each

22.0000

2

4



2
5/11/06/15

D2806-3M



Bushing

Location

Loc Qty

Loc Code

ST022

22

64074

2

68492

20

Manufactured No

130

Each

23.0000

2

4



4
5/11/06/15

D2806-3M



Bushing

Location

Loc Qty

Loc Code

ST022

23

64075

3

69401

20

Manufactured No

110

Each

33.0000

2

4



4
5/11/06/15

D2807-041



Door prop

Location

Loc Qty

Loc Code

ST022

33

60540

2

66336

11

69671

20

4

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2810-5

Manufactured No

130

Each

16.0000



Strut



11/6/15

Location

Loc Qty

Loc Code

ST265

16

52034

1

68493

5

69402

10

2

D2813

Manufactured No

110

Each

34.0000



Washer



4/11/06/15

Location

Loc Qty

Loc Code

ST023

34

61051

13

69386

21

4

D3395-1

Manufactured No

110

Each

52.0000



Bushing



4/11/06/15

Location

Loc Qty

Loc Code

ST052

52

68491

22

69387

30

8

D3396-1

Manufactured No

130

Each

24.0000



Spacer



4

Location

Loc Qty

Loc Code

ST052

24

46748

24

Y

D3562-042

Manufactured No

110

Each

0.0000



Step Assembly, RH



4/11/06/15

B69397 (2)

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

110

Each

345.0000

4



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

273

112314

273



8
5/11/06/15

MS21043-4

Purchased

No

130

Each

1,207.000

4



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

167

117423

167

ST301

1000

117601

500

117793

500



8
5/11/06/15

MS21043-5

Purchased

No

130

Each

511.0000

3



Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

491

112314

391

116548

100



6
11/01/15 8/2

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-302

Purchased

No

110

Each

204.0000

2

4



Cotter Pin



45/11/06/15

Location

Loc Qty

Loc Code

ST309

4

113644

4

ST357

200

117460

200

MS24693-C280

Purchased

No

110

Each

27.0000

2

4



Screw



45/11/06/15

Location

Loc Qty

Loc Code

ST310

26

115594

26

ST318

1

111279

1

NAS1515H3

Purchased

No

110

Each

148.0000

6

12



Washer



45/11/06/15

Location

Loc Qty

Loc Code

ST277

148

116373

48

117460

100

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding

Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H4

Purchased

No

130

Each

188.0000

14



Washer

Location

Loc Qty

Loc Code

ST277

188

111525

2

116169

36

117460

50

117735

100

NAS1515H5

Purchased

No

130

Each

123.0000

14



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

83

109430

83

NAS1515H5L

Purchased

No

110

Each

100.0000

4



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

60

111359

60

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Work Order ID: 69397

Parent Item: D412-630-034

Parent Item Name: Heli Access Step RH Folding



Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1515H8~

Purchased

No

110

Each

259.0000

4

8



Washer



5/11/06/15

8

Location

Loc Qty

Loc Code

ST278

259

111275

59

111411

200

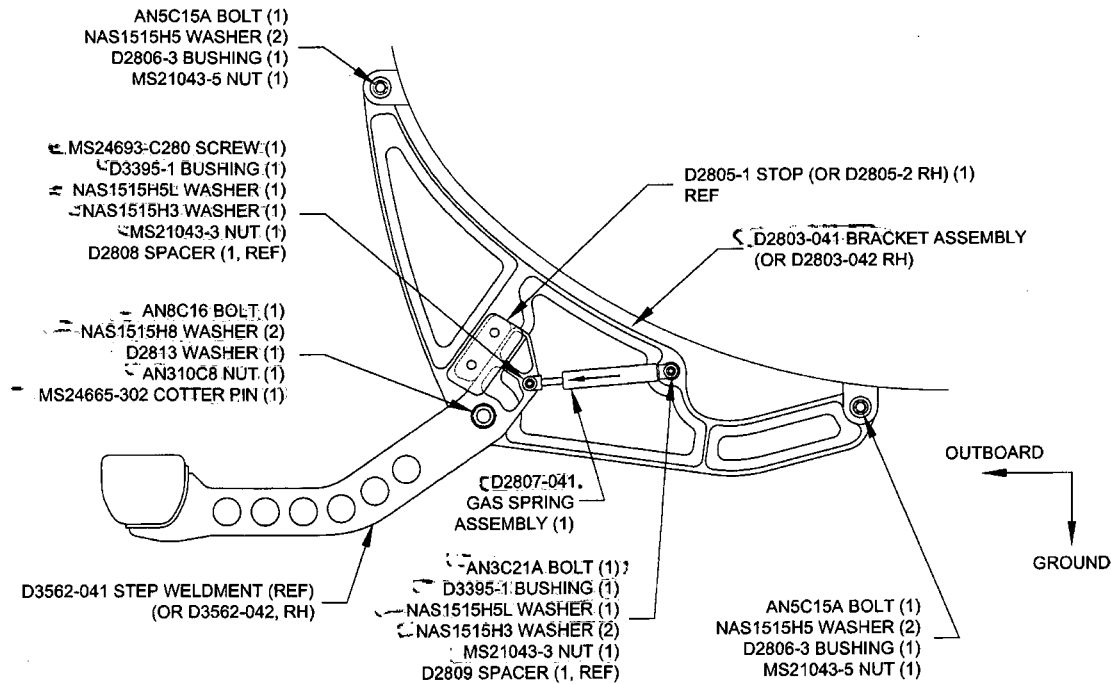
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

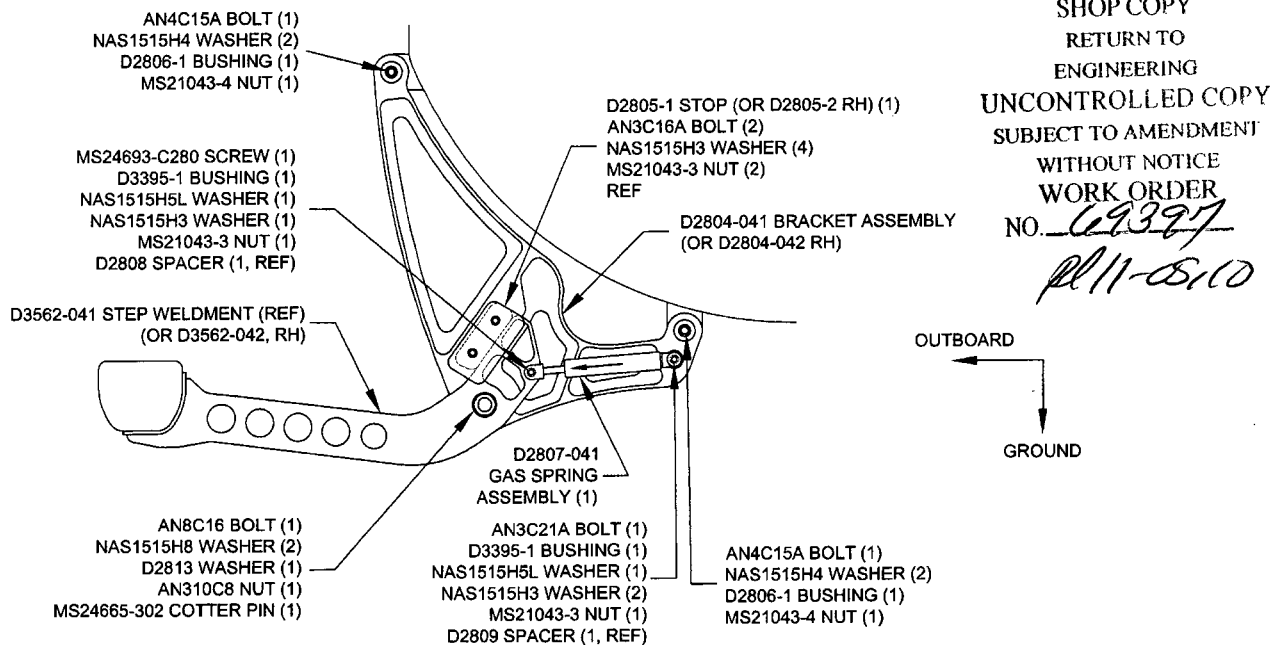


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

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Revision: **M**
Date: 08.12.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09397
11-05-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

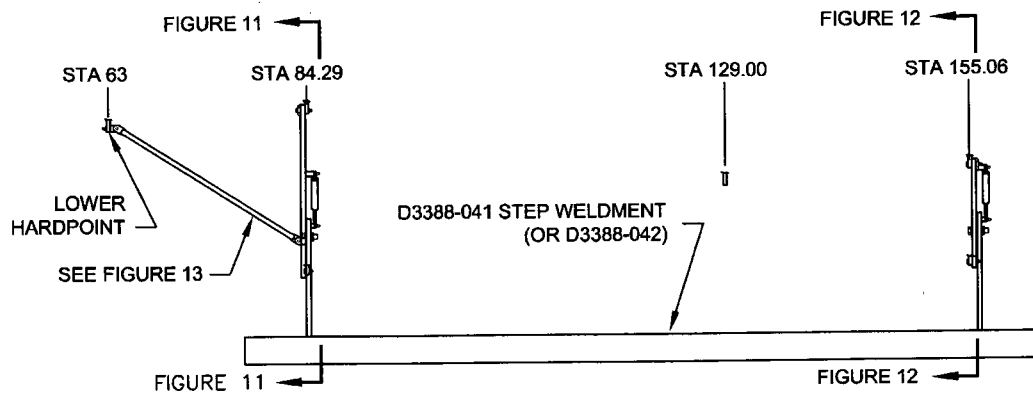
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

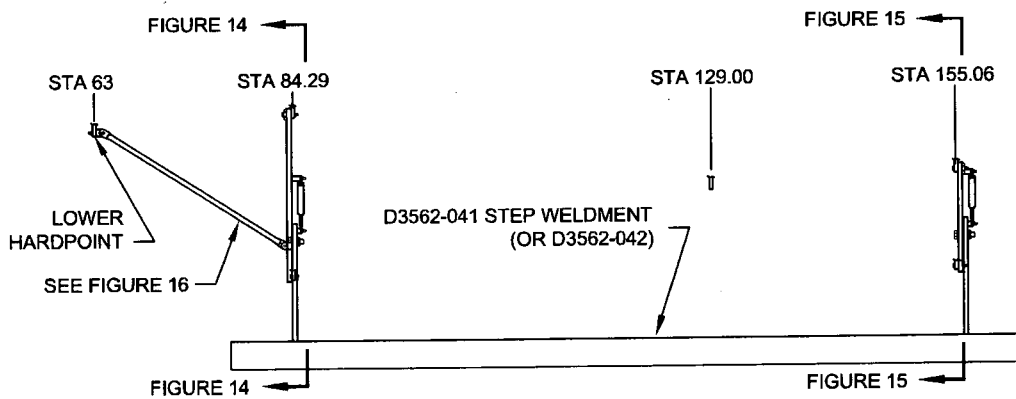
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

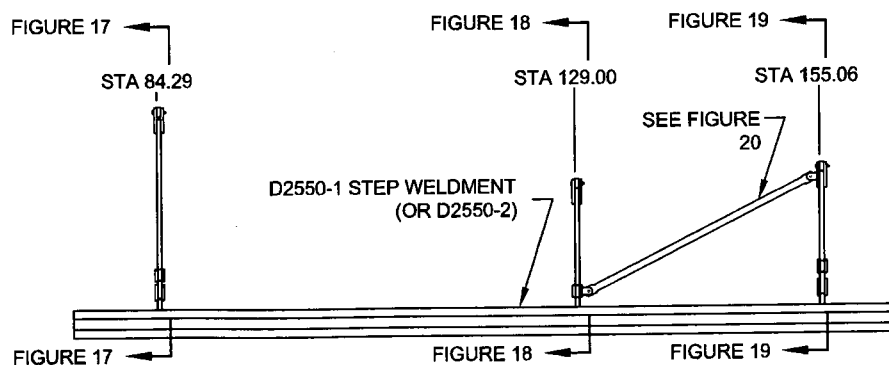


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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Revision: M
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